Work Order ID Wednesday, June 15, 20		M									Page 1
Item ID: D3490 Revision ID:	)-3			Accept				s	Setup Star		
	Bolt Spacer		1 NTEHE 1881 FO	1 1831					Sto	p	
Start Date: 6/15/2 Required Date: 6/22/2 Reference:	•	Qty: 60.00 Qty: 60.00			Cust Item II Customer:	D:					
Approvals: Proce	ess Plan:	V	Date: //06-	5 Toòling:	Da	ite:		R	Run Stai		
QC:			Date:	<b>SPC (Y/N):</b>	Da	ıte:			Sto	P	
Sequence ID/ Work Center ID	Operati Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nb	r		-							
D3490	Rev A							(C)	P	•	
100 	Hardinge	CNC LATHES	SMALL	0.00			,	60	ø		
Hardinge		Memo		0.00					<i>T</i>		
Hardinge CNC Lathe Small		FOLIO REV DWG REV:	PER FOLIO FA629 & I	DWG D3490	1186/16						
110	QC2- Insp	pect parts off ma	achine FAI/FAIB	0.00		•		5 7			
QC		Memo		0.00							
Quality Control			7	11)6	116						
120	QC8- Insp	pect parts - seco	nd check	0.00				_	,		
QC QCality Control		Memo		0.00 Å. 🚓	11/06/21			59	<b>_</b>		

#### Work Order ID 70768

Wednesday, June 15, 2011 9:07:37 AM



Page 2

Item ID:

D3490-3

Accept

Setup Start



**Revision ID:** 

Start Date:

**Item Name:** 

Cross Bolt Spacer

6/15/2011

**Start Oty: 60.00** Req'd Qty: 60.00

**Cust Item ID: Customer:** 

**Tool ID** 

Stop

Reference:

Approvals:

Process Plan:

Date:

**Tooling:** 

Date:

Run Start



Required Date: 6/22/2011

QC:

Date:

\*\*\*STOCK IN SKIDTUBE CELL\*\*\*

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Sequence ID/ Work Center ID

130

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

**Run Hours** 

Set Up/

0.00

0.00

Accept Qty Qty

Reject

Reject Insp. Number Stamp

140

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

Memo

0.00

Mf 06-22

# **Picklist Print**

Wednesday, June 15, 2011 9:07:44 AM

Work Order ID: 70768

Parent Item:

D3490-3

Parent Item Name: Cross Bolt Spacer



Start Date: 6/15/2011

Required Date: 6/22/2011

Page 1

**Start Qty:** 60.00

Required Qty: 60.00

Comments:

IPP Rev:A New Issue 06-03-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0,750		Purchased	No			100	f	58.8030	0,266	16.8			
									<b>                                     </b>	5)	456)	116	

6061-T6 Round Bar .750"

<u>Location</u>	Loc Qty	Loc Code	
MAT013	58.803		
112442	. 0.796		
116406	0.617		
117481	57.39		_17R/

DART AEROSPACE LTD	Work Order:	70768
Description: Crossbolt Spacer	Part Number:	D3490-3
Inspection Dwg: D3490 Rev: A		Page 1 of 1

		FIRS	T ARTICLE IN	NSPECTI	ON CHE	ECKLIST		
	,		X First Artic	cle	Prot	otype		
	rawing nension	Tolerance	Actual Dimension	Accept	Reject	Method o		omments
	3.085	+0.030/-0.000	3.105			3/	1	
(	0.080	+/-0.010	376				,	
Q	0.591	+0.008/-0.001	0.595					
0.0	50 x 45°	+/-0.010 x 0.5°	-020x720		******	-		re were
			0 1000 / 1	-				
						<u> </u>		
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		7						
					-	<del></del>		
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			1					
Measu	ured by:	N-	Audited by:	J.A	11	Prototype	Approval:	N/A
	Date:	11/6/16	Date:	11/06/2	1		Date:	N/A
Rev	Date	Change		· , ·	· •		Revised by	_ Approv∉d
Α	06.10.27	New Issue					KJ/JLM 🚓	

Rev	Date	Change	Revised by	Approve/d
A	06.10.27	New Issue	KJ/JLM	
			 ()	<del>- 7~"/</del> -

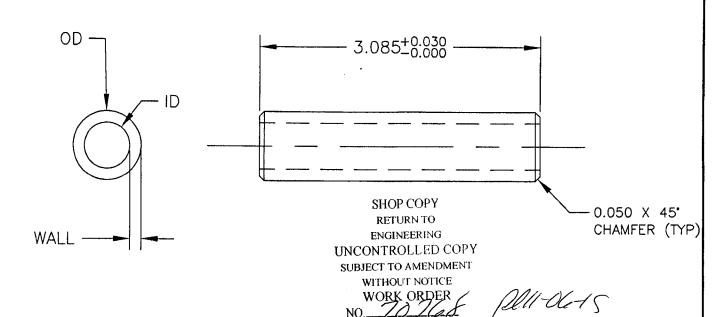
### **Dart Aerospace Ltd**

Duit Au	ospace	L.C.					,					
W/O:		A CONTRACTOR OF THE CONTRACTOR	WO	RK ORDER CHANG	ES				Q <sup>2</sup> T			
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							·					
										:		
Part No	:	PAR #:	Fault Categ	ory:	_ NCR: Yes No DQA:			A:	Date:			
	Re	esolution:	Disposition	•	QA:	N/C CIG	osed:		Date: _			
NCR:			WORK ORDE	R NON-CONFORM	ANCE	(NCR	)					
DATE	STEP	Description of NC			tion B	Ver		fication Approva		Approval		
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector		
•												

NOTE: Date & initial all entries



DESIG	PH	DRAWN BY	DART AEROSPACE U	ISA, INC.
CHECK	ED #	APPROVED 44	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE			TITLE	SCALE
06.0	1.04		CROSS BOLT SPACER	NTS
Α		06.01.04	NEW ISSUF	



### D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

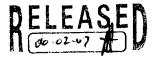
PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
(D3490-3_	0.750	0.080	0.591	M6061T6R0.750 /
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

## D3490-1/-3/-5 CROSS BOLT SPACER

1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)

2) ALL DIMENSIONS ARE IN INCHES

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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Dart Aerospac	e Lto	1
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W/O:			WO	RK ORDER CHANG	GES						
DATE	STEP		OCEDURE CHAN			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			34.44								
				•			·				
							•	,			
Part No	Part No: PAR #		Fault Categ	ory:	NCR	NCR: Yes No DQA:			Date:		
	R	esolution:	Disposition	:	QA:	N/C Clo	sed:		Date: _		
NCR:				R NON-CONFORM							
DATE	STEP	Description of NC	Corrective Action Section B			· · · · · · · · · · · · · · · · · · ·	Verific	ation	Approval	Approval	
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section	on C	Chief Eng	QC Inspector	
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. NOTE: Date & initial all entries